

Date: Wednesday, 25/06/2008 9:21:23 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 39967	
Estimate Number : 11301	
P.O. Number :	Part Number : D34475
This Issue : 25/06/2008 S.O. No. :	Drawing Number : D3447REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 40052	Material :
Written By : <i>[Signature]</i>	Due Date : 02/07/2008 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : A A 05.08.26 New issue KJ/JLM	
Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
-----	--------------	-----------------



Comment: Qty.: 0.3325 f(s)/Unit Total : 1.6627 f(s)
 ROUND BAR 1.00"
 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6R1.000)
 Identify for D3447-5
 Batch: *M 18/47*

RQ 08/06/29

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: DOOSAN CNC LATHE
 Turn as per Folio & Dwg B67-43001Dwg Rev: *A*

RQ 08/06/29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/06/29

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL LATHE
 Drill as per Dwg D3447
 Deburr

Tools: rill

RQ 08/07/03 (C)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/07/03 (C)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 39967

Part Number: D34475

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F. 08/07/04 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-07-07 (6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask 0.875" round section

START TIME:

10:30

OVEN TEMPERATURE:

320

FINISH TIME:

16:00

BL / 08/07/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-10 (6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

Part E

MF 08-07-14

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

Job Completion

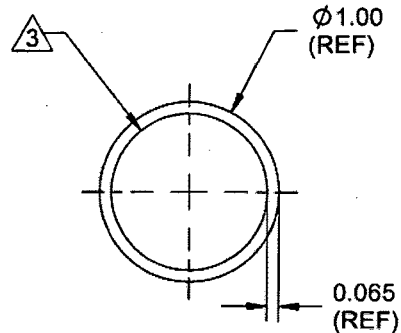
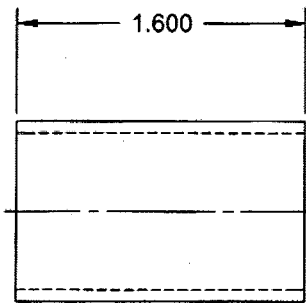


MF 08-07-14

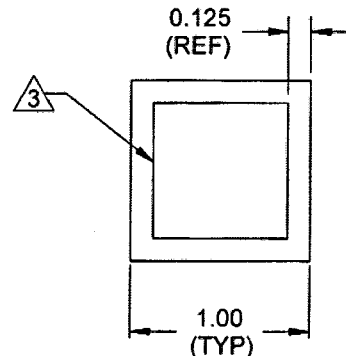
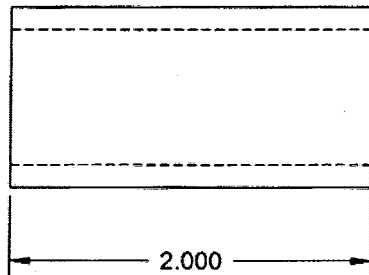
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
[Signature]
05/08/18

**D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)

**D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) MASK INSIDE OF TUBING BEFORE PAINTING.
4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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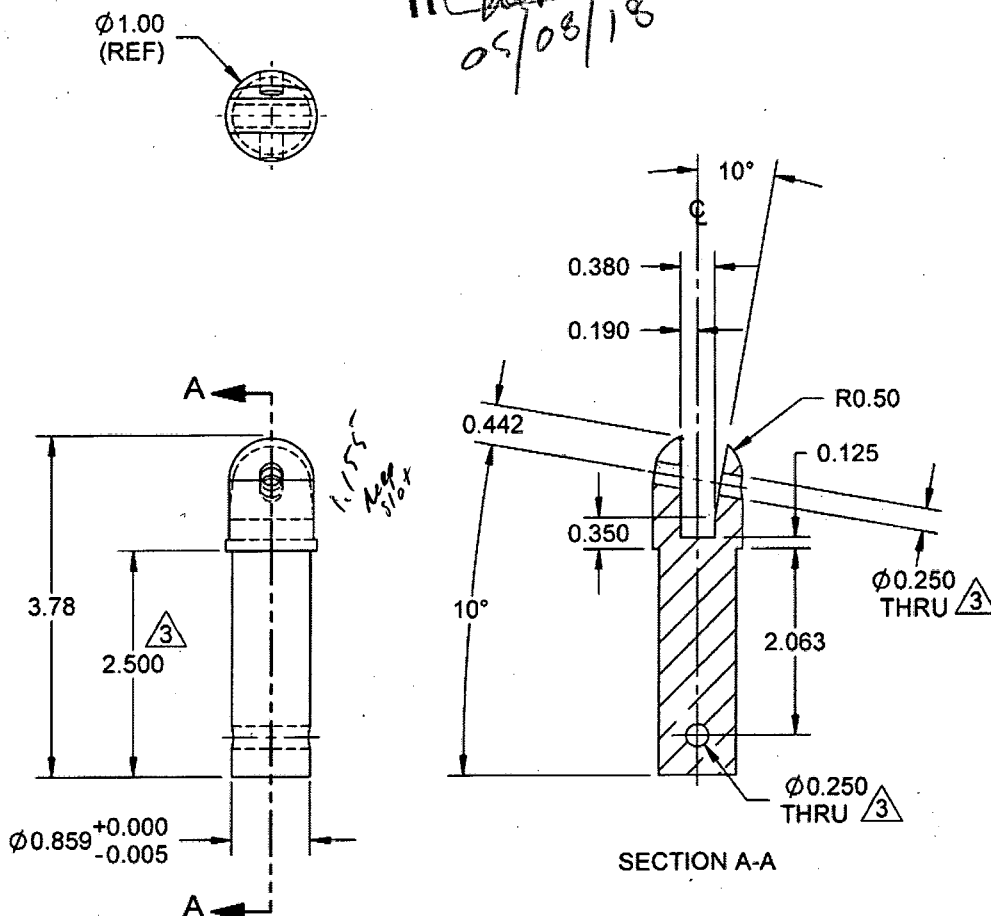
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CHECKED	APPROVED	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19	TITLE BLADE FOLD KIT PARTS		SCALE 1:2

RELEASED
05/08/18

**D3447-5 CLEVIS****SUPERSEDES PREMIER P/N B67-43001-99****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

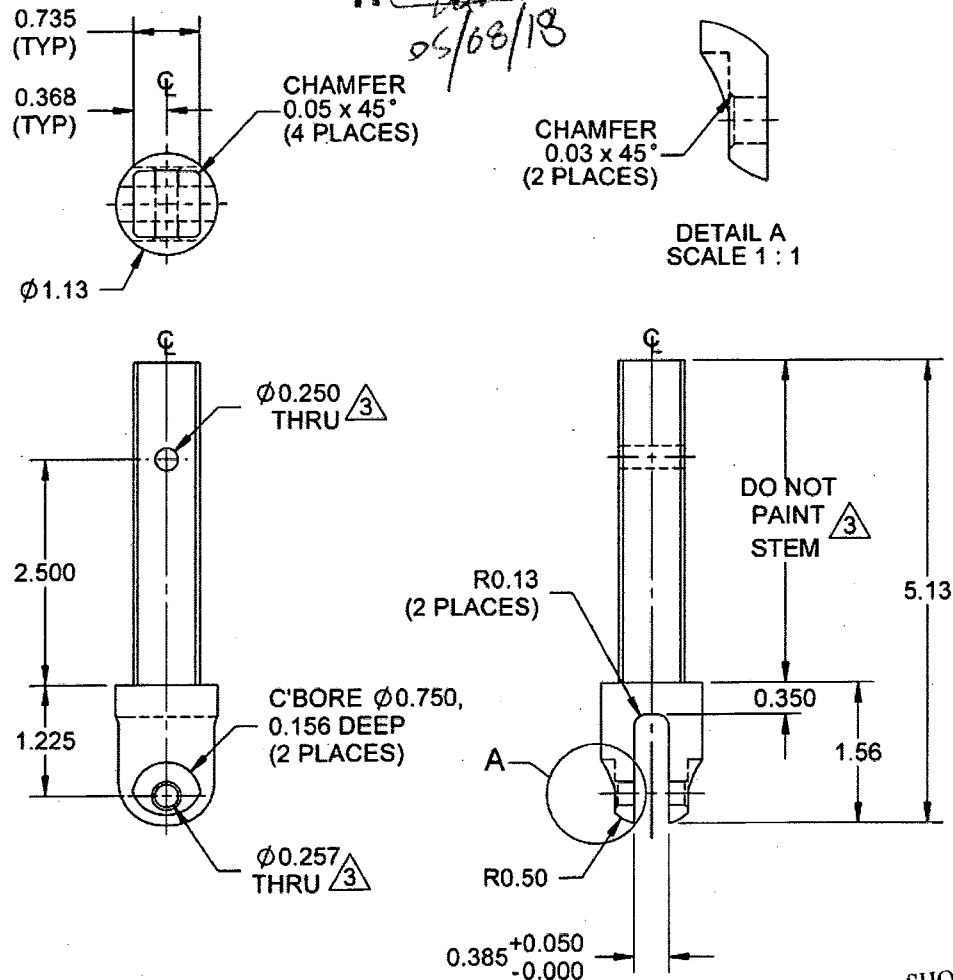
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
05/08/18**D3447-7 CLEVIS****SUPERCEDES PREMIER P/N B67-43001-145/-345****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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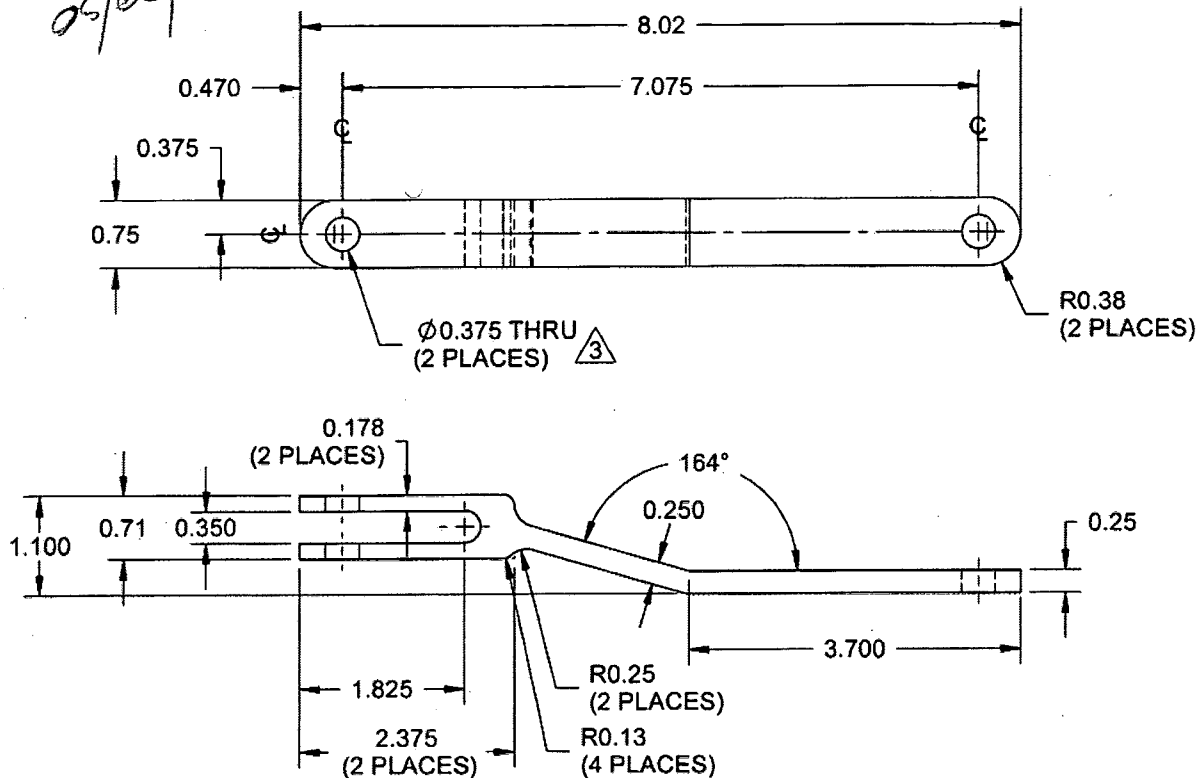
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
[Signature]
05/03/18



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 39967
Description: CLEVIS		Part Number: D3447-5
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.78	+/- .030	3.78				
2.500	+/- .010	2.500				
.859	-.005	.857				
10°	+/- 1/2°	10°				
.380	+/- .010	.325				
.190	+/- .010	.190				
.442	+/- .010	.445				
R.50	+/- .030	R.50				
.125	+/- .010	.125				
.350	+/- .010	.350				
.250	+ .006 - .001	.251				
10°	+/- 1/2°	10°				
2.063	+/- .010	2.063				
.250	+ .006 - .001	.251				
1.00	+/- .030 ^{REA}	1.000				

Measured by: RP	Audited by: J.F.	Prototype Approval: N/A
Date: 08/07/03	Date: 08/07/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	